XX/a	wl _z	$\Omega_{\rm nd}$	er ID	61	025
W O	rk	ura	er III) h4	XZ5

Friday, December 17, 2010 8:04:34 AM



Page 1

Item ID: D3208-3 Accept Setup Start **Revision ID:** Stop Item Name: Pedal Mount Angle Start Date: 12/16/2010 Start Qty: 4.00 **Cust Item ID:** Required Date: 1/19/2011 **Reg'd Oty:** 4.00 **Customer:** Reference: Start Run Date: 10/2-17 Tooling: **Approvals:** Date: Stop Date: **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description Qty **Run Hours** Qty Code Number Stamp Draw Nbr **Revision Nbr** D3208 Rev A1 100 0.00 FLOW WATER JET B11-1-3 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3208 □Dwg Rev: A\ □Prog Rev: A(· □2-6061.063 Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 1B11-1-3 OC 0.00 Memo **Ouality Control** 120 QC8- Inspect parts - second check

. . .

Quality Control

Memo

10/10/ps

(+6)

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								· .	<u></u>
Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	s No DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/C	Closed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Action Description	ion B	ı& ∣ _{Sec}	cation tion C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Dat	e			
					,				
				er e	÷				
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								:	

Work Order ID 64825

Friday, December 17, 2010 8:04:34 AM



Page 2

Item ID:

D3208-3

Accept



Setup Start

Stop



Revision 'D:

Item Name:

Pedal Mount Angle

Start Date:

12/16/2010

Start Qty: 4.00

Req'd Qty: 4.00 **Required Date: 1/19/2011**



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:_____

Tooling: SPC (Y/N):

Set Up/

Date: Date:

Run

Start



Stop

Reject

Qty

Insp.

Stamp

Reject

Number

Sequence ID/

Work Center ID

130

Brake NC

Brake NC

Operation

NC BRAKE

Description

Run Hours

0.00

0.00

Deburr D3208-3 | Form D3208-3 as per Dwg D3208 | Polish any marks on part within 01 of Dwg D3208

Tool # Plan

Code

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O

dulator.

Accept

Qty

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

5 Bf 10-01-5.

Memo

Memo

W/O:				WORK ORDER CHA	NGES				
DATE	STEP		PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:									
Part No	o: <u>B3</u>	२०६- ३	PAR #:	Fault Category: Small Fab.	NCR: Yes	No DQ	A:	Date: _/	14:01:05
	F	Resolution:	Scrw	Disposition: Surme	QA: N/C	_ Closed:(Z	∑ Date: _	11/01/06

NCR: 64	825	W	ORK ORI	DER NON-CONFORMANC	E (NCR)			•
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
11/01/05	130	I part uns out of Tolerance. Slipped while benefing ? Bench was on an anyle across the part. R.L. process	psiuz	Scrop v destroy	SD 1401/85	8 world	OSIVYZ	/word

Work Order ID 64825

Friday, December 17, 2010 8:04:34 AM



Page 3

Item ID:

D3208-3

Accept

Setup Start



Revision ID:

Item Name:

Pedal Mount Angle

Start Date:

12/16/2010

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Run

Start

Stop



Required Date: 1/19/2011

QC:

Date:_____

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Stop

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Set Up/ **Run Hours** 0.00

Reject Qty

Reject Insp. Number

Stamp

170

Packaging

Packaging

Memo

Accept

Qty

180 QC

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location: 262

0.00

0.00

0.00

Memo

Memo

0.00

										
W/O:			W	ORK ORDER CHANGE	ES					٠
DATE	STEP	PRC	OCEDURE CHA	NGE	Ву		ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
A. C.		***************************************								
Part No	:	PAR #:	Fault Cate	egory:	NCR: Ye	es No	DQA		Date:	
	R	esolution:	Disposition	on:	QA: N/C	Close	ed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sig	n &	Verific Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Da	ite				
								•		
					ļ 1					

Picklist Print

Friday, December 17, 2010 8:04:38 AM

Work Order ID: 64825

Parent Item:

D3208-3

Parent : em Name: Pedal Mount Angle



Start Date: 12/16/2013

Required Date: 1/19/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: BE 04.05.25 L! Material changed for Step 4 \square KJ/JLM \square

IPP Rev:C Now on Waterjet 06-10-12 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	148.6340	0.0659	0.277474	15		,
										13	(- 1 - 3	>	

6061-T6 .063 Sheet

Location	Loc Oty	Loc Code		
MAT	111			7.7
116308	111		116308)	(6)
MAT21	37.634			\cup
113608	37.634			

	•								
W/O:			WO	RK ORDER CHANG	ES	**************************************			
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A :	Date: _	
	R	esolution:	Disposition	:	_ QA: N/C Cid	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
									
								į	

DART AEROSPACE LTD	Work Order:	441875
Description: Pedal Mount Angle	Part Number:	D3208-3
Inspection Dwg: D3208 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

·		X First Artic	le	Protot	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.001	.100	%		V BUZ	
1.651	+/-0.010	1.655	*		V	
5.250	+/-0.010	5.254	≯ 2		V	
0.125	+/-0.010	,118	X		V	
		,				
				-		
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*	-					-
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					,	
			 			

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-1-3	Date: 11/01/03	Date:	N/A

F	Rev	Date	Change	Revised by	Approved
	Α	06.10.27	New Issue	KJ/JLM	
_					7,007

	. John J											
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
												
Down No.		DAD #	F!! O-1		NOD: Vac	No DO		Data				
Part No		PAR #:										
Resolution:		Disposition: QA: N/C Closed: Date:										
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR	l)						
DATE	STEP	Description of NC	Corrective Action Section			Verific		Approval	Approval QC Inspector			
DATE	Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	Section C Chief Eng					
				· · · · · · · · · · · · · · · · · · ·								

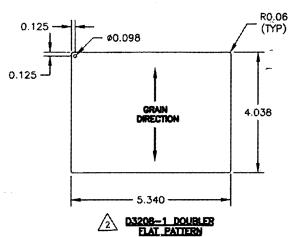
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04.01.27 NEW ISSUE IF OH. US 25 CHANGE DIM, NOTE 3) CHANGE



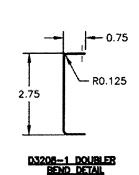
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CRAIN

5.250

DAZON-3 PEDAL MOUNT ANGLE

DIRECTION



SHOP CODY RETURNED

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE

- 1.00 RO.156 0.80

WORK ORDER

D3208-3 PEDAL MOUNT ANGLE BEND DETAIL

NOTES:

0.125

0.125

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)

R0.06

(TYP)

1.651

- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES

3) MATERIAL: 6061-TE (QQ-A-250/H) 0.063" THICK (M6061TES.063)

	4	*										
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Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	DQA: Date:					
Resolution:		esolution:	Disposition: Q/			A: N/C Closed: Date:						
NCR:			WORK ORD	ER NON-CONFORMAI	NCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B				fication	Approval Chief Eng	Approval QC Inspector			
<i></i>	0.2.		Initial Chief Eng	Action Description Chief Eng	Sign & Date							
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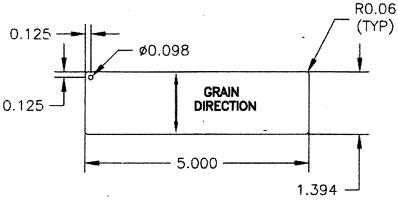


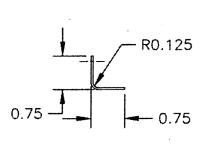


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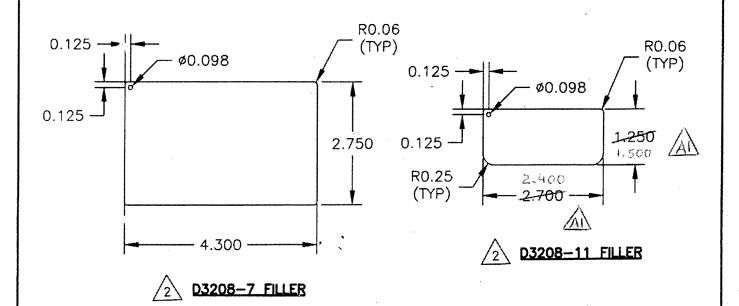


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D3208-5 MOUNT ANGLE BEND DETAIL



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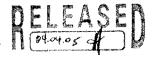
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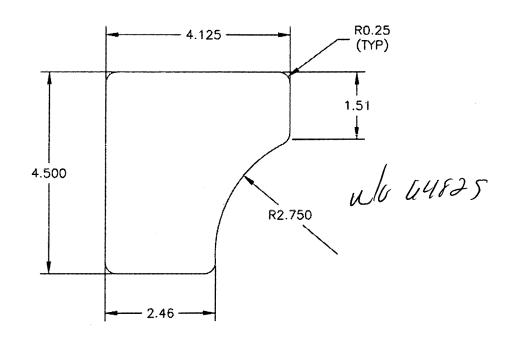
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Res		esolution:	Disposition	n:	QA: N/C Closed:			Date:			
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	₹)					
DATE	CTED	Description of NC	Corrective Action Section			Verifi	cation	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date						
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D3208-9 DOUBLER

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No: PAR #:		PAR #:	Fault Cate	gory:	NCR: Yes	es No DQA: Date:					
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		Description of NC	Corrective Action		Section B Verifi		cation Approva	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	tion C	Chief Eng	QC Inspector		
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